

Work Order ID 53807

November 18, 2009 12:46:39 PM



Page 1

Item ID: D2278

Accept



Setup Start



Revision ID: F

Stop



Item Name: Step Leg

Start Date: 18/11/2009 Start Qty: 12.00

Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *RL*

Date: *02/11/14*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2278

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2278
Deburr if necessary

☐ Dwg Rev: *f*

☐ Prog Rev: *f*

☐ 2-

600' .000

18-9-12-3



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

18-9-12-3

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 18-12-10-3

counted



f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No, DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

54254 Deriv

Work Order ID 53807



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Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	MD 09/12/04			X22			
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	H 09/12/04			X22	0		
150 Packaging Packaging	Identify as per dwg & Stock Location: GA Memo	0.00 0.00	509/12/07						(22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53807

November 18, 2009 12:46:39 PM



Page 3

Item ID: D2278

Accept



Setup Start



Revision ID: F

Stop



Item Name: Step Leg

Start Date: 18/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/07

u 9-1207

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 18, 2009 12:46:45 PM

Page 1

Work Order ID: 53807



Parent Item: D2278RevF



Parent Item Name: Step Leg

Start Date: 18/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

161.8809

123979

23.



189-12-3

6061-T6 .080 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

161.88087

107904

0.02

110254

1.5

110630

33.5136

112040

0.0437

112141

9

112512

0.2784

112763

117.52517

112763

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	53807
Description: Leg		Part Number:	D2278
Inspection Dwg: D2278 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.354	+/-0.010	.354	x			
0.354	+/-0.010	.355	x			
16.46	+/-0.030	16.46	x			
Ø0.128	+0.005/-0.000	.132	x			
R0.354	+/-0.030	.354	x			
2.00	+/-0.030	2.000	x			
4.74	+/-0.030	4.743	x			
8.46	+/-0.030	8.470	x			
0.213	+/-0.010	.218	x			
0.750	+/-0.010	.751	x			
0.080 thick	+/-0.010	.077	x			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-12-3	Date: 09/12/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev. changed	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	08.02.28	Dimensions updated per Dwg Rev F	KJ/DD	DD

